

Work Order ID 135241

August 06, 2015 7:49:09 AM

ACCEPTABLE TO SHIP 15-08-06
D2724-1-041
B135241
REV. C

135241

Page 1

Item ID: D2724-041

Revision ID:

Item Name: 206L Step Assembly, LH

Start Date: 8/6/2015 Start Qty: 4.00

Required Date: 8/13/2015 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: SM

Date: 20150806 Pooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan- Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	---------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2724	Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

4 8 BE15-08-10

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT10063

A/R AL ROD Batch: M131562 / M130137
Grind end cap welds flush

4 8 BE15-08-12

120

0.00

120

QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

Quality Control

④ 15-08-12

DAS
9
9-89

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Item ID: D2724-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206L Step Assembly, LH

Start Date: 8/6/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/13/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

④ 15-08-12DAS
9
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

4 0 15-8-12 *DEL*DAS
18
9-89

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

4 0 15-08-12

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Item ID: D2724-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L Step Assembly, LH
Start Date: 8/6/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/13/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing									
230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location:	0.00							
240									
Packaging	Memo	0.00							
Packaging									

Handwritten notes: 131644X1, 135728, 4, 15-8-19, 38, 9-89, AUG 20 2015, MJS, AUG 20 2015

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Item ID: D2724-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L Step Assembly, LH
Start Date: 8/6/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/13/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

MLJ AUG 20 2015

Picklist Print

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Page 1

Work Order ID: 135241

135241

Parent Item: D2724-041

D2724-041

Parent Item Name: 206L Step Assembly, LH

Start Date: 8/6/2015

Required Date: 8/13/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

88.0000

1

4

D2622-120C

Step Extrusion

**

BE15-08-10

Location

Loc Qty

Loc Code

WA003

88

130161

88

D2734

Manufactured

No

110

Each

93.0000

1

4

D2734

Step End Plate

**

BE15-08-12

Location

Loc Qty

Loc Code

WA003

93

130983

43

133142

20

134415

30

D3458-1

Manufactured

No

110

Each

23.0000

2

8

D3458-1

Step Mounting Plate

**

BE15-08-10

Location

Loc Qty

Loc Code

WA003

10

120233

8

122211

2

WA004

13

160460

13

Picklist Print

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Page 2

Work Order ID: 135241

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Parent Item: D2724-041

D2724-041

Parent Item Name: 206L Step Assembly, LH

Start Date: 8/6/2015

Required Date: 8/13/2015

Start Qty: 4.00

Required Qty: 4.00

D3458-3

Manufactured No

110

Each

13.0000

2

8

D3458-3

Step Mounting Plate

BE15-08-10
8134963 x 4

Location

Loc Qty

Loc Code

WA003

2

122212

2

WA004

11

12

130461

11

D2734

Manufactured No

160

Each

93.0000

1

4

D2734

Step End Plate

BE15-08-13

Location

Loc Qty

Loc Code

WA003

93

130983

43

133142

20

134415

30

MS20601AD4W2

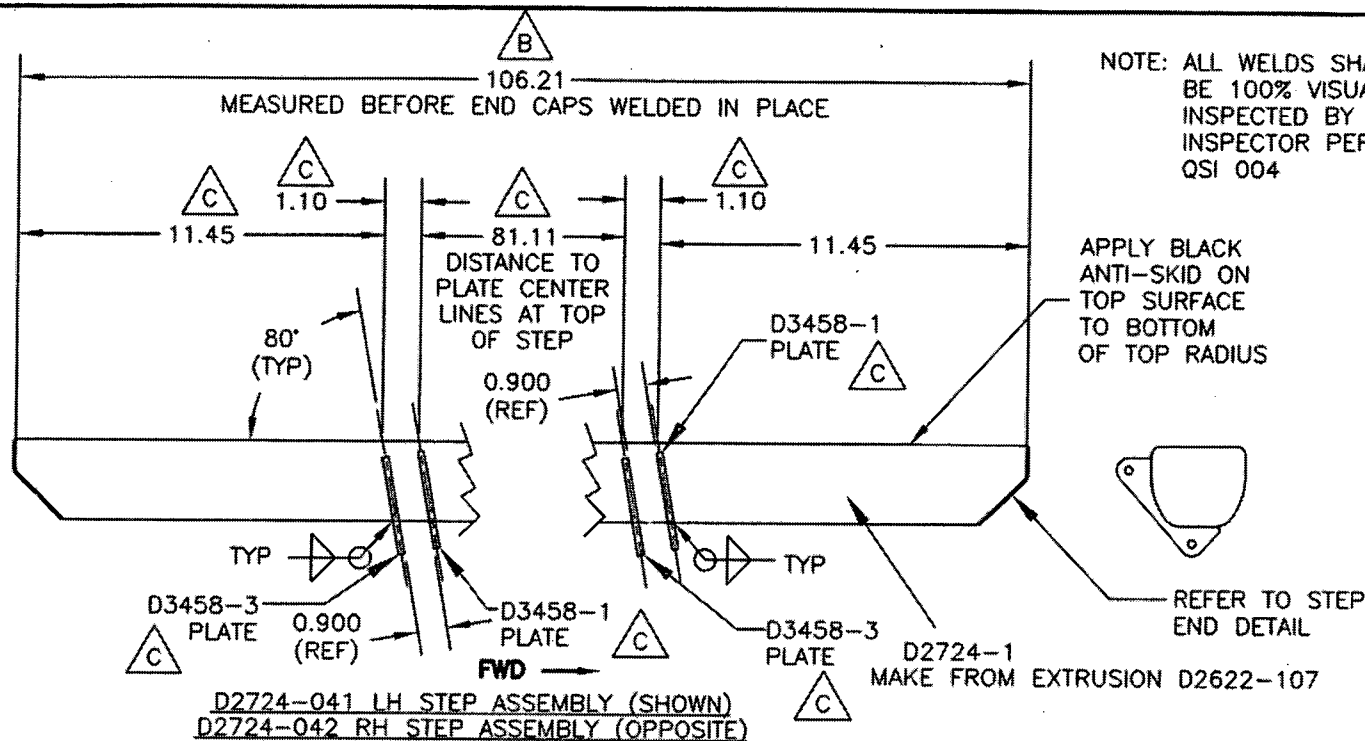
MS20601AD4W2

4

B 132283

BE15-08-13

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NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

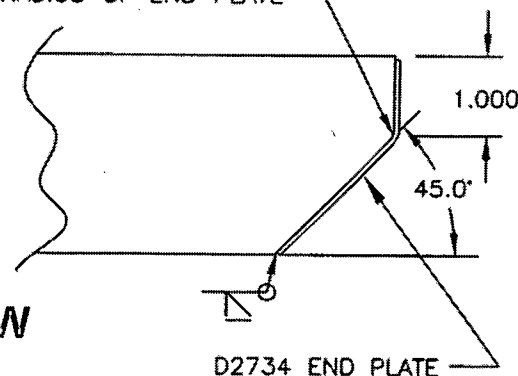
— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

UNDER REVIEW

14.12.10 AJS

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL 3
2) WELD PER DART QSI 004 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 54

5 4.3 135241
561 20150806

RELEASED

05.11.14

DART

CHECKED KE		APPROVED PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. C
DATE	05.09.19		DRAWING NO. D2724	SHEET 1 OF 1
			TITLE	SCALE
A		97.12.04	206L/407 STEP ASSEMBLY	NTS
B		98.10.19	NEW ISSUE	
C		05.09.19	UPDATED WELD DETAIL REVISED TOLERANCES	
			RE-DESIGN, ADD D3458-1/-3	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Swat Date: 15/08/24

QA Closed:

Date:

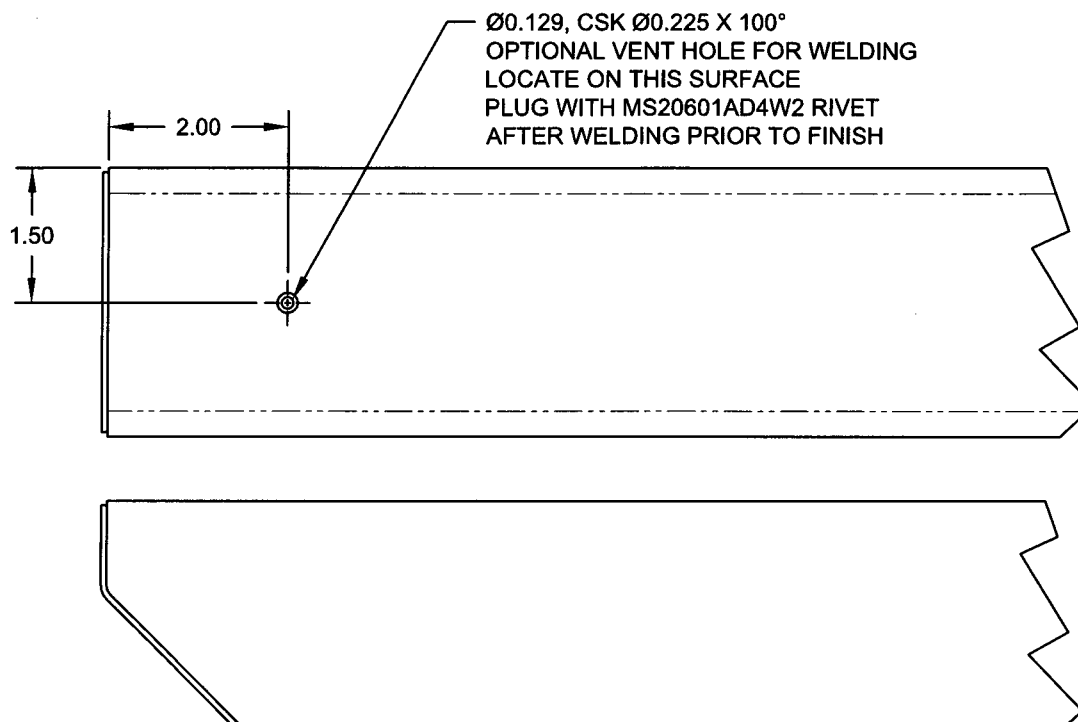
Work Order: <u>135241</u> Part No. <u>02724-042</u> NCR No. <u>15-5204</u>				DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data	15.08.06	110	4	DRAWING UP. TO ADD VENT HOLE FOR WELDING	A.P. 15.08.06	ACCEPTABLE PER PRELIM DEO ATTACHED	BE 15.08.13	DAS 9 9-89 15.08.13	DAS 9 9-89 15.08.13		
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved	☒										

FAULT CATEGORY			
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped. ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☒ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DRAWING NO. D2724	TITLE 206L/407 STEP ASSEMBLY	REV. <i>PC1</i>	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2724-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS		CHECKED	MFG. APPR.		APPROVED	DE APPR.	
DATE 14.12.09		DATE	DATE		DATE	DATE	

REF PAR 14-355

ADD VENT HOLE AND MS20601AD4W2 RIVET AS SHOWN BELOW:



PRELIMINARY ISSUE
AJS 14-12-09

ADD MS20601AD4W2 RIVET TO PARTS LIST AND CORRECT TYPO AS SHOWN:

IS: D2724-041/-042 STEP ASSEMBLY PARTS LIST

WAS: D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE
1	1	MS20601AD4W2	RIVET (OPTIONAL)

ADD: —

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